

Work Order ID 116461

April-16-14 11:00:36 AM

\*116461\*

Page 1

Item ID: D407-667-205

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Crosstube

Start Date: 4/16/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-04-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D407-667-245	Rev F/DEO
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100	Document Control	0.00
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\*100\*

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels as per PPP D407-667-205 CHG008

MAY 14 2014

DAS  
28  
9.88

MAY 14 2014

110	Pick Kit	0.00
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\*110\*

Packaging

Packaging

Packaging

Memo

0.00

14-04-21

14-04-21

120	BENDING MACHINE - CROSSTUBES	0.00
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\*120\*

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - CROSSTUBES

Memo

0.00

1-Bend tube as per Dwg D407-667-245 using CNC bender program 407 Aft and Folio 21

14-04-21

14-04-21

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Page 2

Item ID: D407-667-205

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

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Start Date: 4/16/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC15- Crosstube Dimensional Check

0.00

\*130\*

QC

Memo

0.00

Quality Control

DAS  
03  
2-89



14-4-22



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Item ID: D407-667-205

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\*N900040100\*

Setup Start \*NS1\*

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Stop \*NS2\*

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Start Date: 4/16/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00

\*140\*

Crosstubes

Crosstubes

Crosstubes

Memo

0.00

\*\*\*\*\* ENSURE PROPER JIG POSITIONING BEFORE DRILLING\*\*\*\*\*  
VERIFIED BY:                      \*\*\*\*\*

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill all (3) top holes. Holes facing inboard. Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245

\*\*\*\*\* ENSURE PROPER JIG POSITIONING BEFORE DRILLING\*\*\*\*\*  
VERIFIED BY:                      \*\*\*\*\*

2- Drill fwd rivet holes using drill Jig DT8787 fwd as per Dwg D407-667-245.  
Note: FWD side has 3X top holes facing inboard.

3- C'sink holes as per dwg D407-667-245. Allow rivet to sit below surface to compensate for paint.

4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most, bottom hole to prevent accidental drilling. Drill holes and ream using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill only the top (2) holes. Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245.

\*\*\*\*\* ENSURE PROPER JIG POSITIONING BEFORE DRILLING\*\*\*\*\*  
VERIFIED BY:                      \*\*\*\*\*

5-Drill aft rivet holes using drill Jig DT8787 aft as per Dwg D407-667-245.

BL/83 14-04-24

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Item ID: D407-667-205

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Crosstube

Start Date: 4/16/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Drill only the top (2) holes.

\*\*\*\*\* ENSURE PROPER JIG POSITIONING BEFORE DRILLING\*\*\*\*\*  
VERIFIED BY: SL/8 \*\*\*\*\*

6- C'sink holes as per dwg D407-667-245. Allow rivet to sit below surface to compensate for paint.

7- Scribe tube to identify on the inner chamfer in the cuff D# and B#

8-\*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\*Deburr  
& Inspect for surface damage. Repair damage within limits as per Dwg D407-667-245

SL/8 14-04-24

EP 14-04-28

150

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

**\*150\***

QC

Memo

0.00

Quality Control

\*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\*

14/4/28

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**\*116461\***

Page 5

Item ID: D407-667-205

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Crosstube

Start Date: 4/16/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

**\*160\***

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

\*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\*

1- CLEAN CROSSTUBE WITH WASH'N WIPE

1 0 0 14-4-29

180

Outsource process - NDT per QSI038 4.1

0.00

**\*180\***

Outsource2

Memo

0.00

Outsource process - NDT

\*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\*

Liquid Penetrant Inspection as per QSI 0380  
Issue P/O: 23989 LPI as per ASTM 1417  
Level 2 Attach copy of NDT results to work order

CL 14/04/29 ①

190

0.00

**\*190\***

Packaging

Packaging

Memo

0.00

Packaging

\*\*\* WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE\*\*\*

Ensure copy of NDT results attached to work order.

14/4/29 ①

Work Order ID 116461

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April-16-14 11:00:36 AM

Item ID: D407-667-205 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Aft Crosstube  
 Start Date: 4/16/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/01/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	DAS 27 9.39	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200	QC5- Inspect part completeness to step on W/O	0.00								
*200*	QC	0.00	14/4/29							
Quality Control	Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***									

204		0.00								
*204*	HandFXtube	0.00								
Hand Finishing Crosstubes	Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***  1- PRESSURE WASH AND THEN USE WASH'N WIPE TO CLEAN CROSSTUBE BEFORE CHEMICAL CONVERSION									

206	QC7-Inspect Chemical Conversion Coat	0.00								
*206*	QC	0.00	5/1/11							
Quality Control	Memo *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***									

*Handwritten signature and date: 14-04-29*

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Item ID: D407-667-205

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Crosstube

Start Date: 4/16/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	SprayPaint	0.00							
<b>*210*</b>									
SprayPaint	Memo	0.00							
Spray Painting	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
	***Mask underside of crosstube as shown***								
	1-Prime inside and outside crosstube as per DEO D407-667-245 and QSI 005 4.2								
	2-Paint outside crosstube with White Imron as per QSI 005 4.2								
	PRIME: 124 403								
	Start Time: 8:00								
	Finish Time: 8:30								
	PAINT: m 128 574								
	Start Time: 3:00								
	Finish Time: 3:30								
220	QC14- Inspect Spray Paint	0.00							
<b>*220*</b>									
QC	Memo	0.00							
Quality Control	Then, Wrap in plastic bag to protect from scratches								



# Non-Conformance Report

<b>Reviewed</b>		Printed on: Friday, May 02, 2014
<b>DQA:</b>		
<b>Date:</b>		

<b>Details</b>			
<b>Raised Date</b> 5/2/2014	<b>Status</b> Open	<b>Owner</b> Forbes, Nigel	<b>Number</b> NCR14-3817
<b>Target Date</b> 5/19/2014	<b>Standard</b>	<b>Severity</b> MAJOR	
<b>Process</b> Employee Suggestion		<b>Audit</b>	
<b>Raised By Person</b> Downing, Eric M	<b>Raised Against (Department or Supplier)</b> Manufacturing		<b>Fault Category</b> General\BOM/Route
<b>Details</b> was noticed by painter that he did not mask center strip in D407-667-205 inspection window on qty x 4 cross tubes B116464, B116463, B112864, B116461			
<b>Keywords</b> inspection window		<b>Product</b> D206-667\D407-667-205	
<b>Document</b>		<b>Root Cause</b>	
<b>Closed By</b>	<b>Closed Date</b>	<b>Resolution</b>	

<b>Corrective Action</b>			
<b>Target Date</b> 5/19/2014	<b>Owner</b> Downing, Eric M	<b>Closed Date</b>	<b>Closed By</b>
<b>Details</b>			

<b>Actions</b>			
<b>Number</b>	<b>Owner</b>	<b>Target Date</b>	<b>Completed Date</b>
<b>Details</b>		<b>Response</b>	
1	White, Jesse	5/9/2014	
using a line mate grinder buff longitudinally the paint & primer on the inside bend of the cross tube as specified in the drawing		JW 14-05-04	
2	Murdoch, Matthew	5/9/2014	
scuff / sand paint lightly to help blend in strip tube		AR 14-5-4	
3	Murdoch, Matthew	5/9/2014	
re alodine area as per QSI 005		B/S	

4	Murdoch, Matthew	5/9/2014	
re prime as per Dwg & per QSI 005		128826	AB 14-5-9
5	Murdoch, Matthew	5/9/2014	
per paint per Dwg & QSI 005 and re clear coat		128464	AB 14-5-9 (21 14-05-10)
6	Duval, David	5/16/2014	
update all cross tube work orders to have priming & painting as two different steps			

### Verification & Review

Target Date	Owner	Closed Date	Closed By
Details			

### Actions

Number	Owner	Target Date	Completed Date
Details		Response	

Work Order ID 116461

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Item ID: D407-667-205

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Crosstube

Start Date: 4/16/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230

0.00

\*230\*

Crosstubes

Crosstubes

Memo

0.00

1- Install chafing shield as per DEO D407-667-245. Top holes should be facing up.

A/R Proseal 890 Batch: 128712 14-5-13  
EXP: 10/14

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3- Install support with Scotch-Weld DP460 and install clamps as per DEO Dwg D407-667-245 using installation jig DT9025. Torque clamps as per dwg

A/R Scotch-Weld DP460 Batch: 1128480  
EXP: 13/03

\*\*\*LET CURE FOR 24 HOURS\*\*\*

CURE TIME:

START: 14-5-11

FINISH: 14-5-12

4- Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint.

1 \_\_\_\_\_ CL 14-05-11

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**\*116461\***

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Item ID: D407-667-205

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Crosstube

Start Date: 4/16/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
<b>*240*</b>									
QC	Memo	0.00							
Quality Control	***RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURE FOR 24HOURS AS PER DWG DEO***								
250	Pick Kit	0.00							
<b>*250*</b>									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>									
QC	Memo	0.00							
Quality Control									

*DMF*  
*14/5/14*

*12/5/12* *(1)*

DAS  
32  
9-89



DAS  
06  
9-89

*1X*

DAS  
28  
9-89

MAY 14 2014

**Work Order ID 116461**

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**\*116461\***

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Item ID: D407-667-205

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**\*N900040100\***Setup Start **\*NS1\***

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Start Date: 4/16/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00 **\*1\***

Customer:

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Run Start **\*NR1\***

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Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00

**\*270\***

Packaging

0.00

Packaging

Memo

Identify and in kanban rack  
Location: 113

IX

DAS  
28  
9-89MAY 15 2014  
DAS  
06  
9-89

280

0.00

**\*280\***

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

14/5/15

14-5-15

# Picklist Print

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Work Order ID: 116461

**\*116461\***

Parent Item: D407-667-205

**\*D407-667-205\***

Parent Item Name: Aft Crosstube

Start Date: 4/16/14

Required Date: 5/01/14

Start Qty: 1.00

Required Qty: 1.00

**Comments:** IPP Rev:C 05.09.02 Add holes for compatibility with Bell SkidtubesKJ/JLM  
IPP Rev:D Added Magnobond,Rubber Cushion & Clamps 07-02-19  
JLM

\*\*\*CHANGE TO CHG 005 - IF USING D2894-1 B35578 OR GREATER\*\*\*

IPP Rev:E 08-05-22 add comment in seq. 6 and QC15 and QC5 DD verified by:EC

IPP Rev:F 08-06-12 add comment in seq. 24 DD verified by:EC

IPP Rev:G 08-08-19 revE as per dwg DD verified by:EC

IPP Rev H 09.01.06 ECN 08-562 EC verified by:DD IPP Rev:I

10.04.07 revise route seq. in bom DD verified by:JLM IPP Rev J 11.04.26

removed abrasion strip ecn 11-551 EC verified

by:DD

IPP REV:K

11.10.03 DEO D407-667-245-F-2 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D407-667-205TRN

Manufactured No

110

Each

10.0000

1

1

**\*D407-667-205TRN\***

★★

Crosstube Turning Detail

Location	Loc Qty	Loc Code
LG	3	
105222	1	
115331	1	
115363	1	
LG014	7	
105224	1	
105225	1	
108604	1	
108606	1	
108607	1	
115332	1	
115334	1	

JW 14-04-21

# Picklist Print

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Parent Item Name: Aft Crosstube

Start Date: 4/16/14

Required Date: 5/01/14

Start Qty: 1.00

Required Qty: 1.00

D2873-043

Manufactured No

230

Each

116.0000

2

2

**\*D2873-043\***

Nut Plate Assembly

**\*\***

CR 14-05-01

Location

Loc Qty

Loc Code

LG052

116

104871

1

107964

10

112264

25

113050

40

114550

40

D2873-045

Manufactured No

230

Each

119.0000

2

2

**\*D2873-045\***

Nut Plate Assembly

**\*\***

CR 14-05-01

Location

Loc Qty

Loc Code

LG

34

112430

34

LG052

85

108829

5

113144

40

113886

40

D2894-1

Manufactured No

230

Each

18.0000

1

1

**\*D2894-1\***

2.75 Support

**\*\***

CR 14-05-11

Location

Loc Qty

Loc Code

LG052

18

103950

2

105623

6

113132

10

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Shop Packet Print

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**\*116461\***

Parent Item: D407-667-205

**\*D407-667-205\***

Parent Item Name: Aft Crosstube

Start Date: 4/16/14

Required Date: 5/01/14

Start Qty: 1.00

Required Qty: 1.00

D3190-1      Manufactured      No      230      Each      43.0000      2      2

**\*D3190-1\***

Chaffing Shield

\*\*

*AR 14-5-13*

Location      Loc Qty      Loc Code

LG053

43

105834

29

109948

14

D3595-063-450      Manufactured      No      230      Each      85.0000      2      2

**\*D3595-063-450\***

Rubber Cushion

\*\*

*CR 14-05-11*

Location      Loc Qty      Loc Code

FG

15

88422

5

94274

10

LG

15

111538

15

LG051

55

109526

2

113323

28

115271

25

MS20601-AD4W8      Purchased      No      230      Each      653.0000      14      14

**\*MS20601-AD4W8\***

RIVET

\*\*

*CR 14-05-01*

Location      Loc Qty      Loc Code

ST311

653

M126637

24

M127813

129

M128429

200

M128650

300

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Shop Packet Print

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**\*116461\***

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**\*D407-667-205\***

Parent Item Name: Aft Crosstube

Start Date: 4/16/14

Required Date: 5/01/14

Start Qty: 1.00

Required Qty: 1.00

MS21920-22

Purchased

No

230

Each

307.0000

4

4

**\*MS21920-22\***

Clamp

\*\*

~~CR 14-05-11~~  
A8 14-5-13

Location

Loc Qty

Loc Code

LG

200

M128636

200

LG050

107

M127255

40

M127608

19

M128199

48

4

MS21920-25

Purchased

No

230

Each

86.0000

2

2

**\*MS21920-25\***

Clamp

\*\*

CR 14-05-11

Location

Loc Qty

Loc Code

FG

2

120920

2

LG050

84

M127823

25

M128012

9

M1285701

25

M128718

25

2

NAS1149D0563J

Purchased

No

230

Each

4,532.000

18

18

**\*NAS1149D0563.J\***

Washer

\*\*

DAS  
32  
9-89

14/07/11

Location

Loc Qty

Loc Code

GA

201

m125807

201

ST510a

4331

m126319

2331

m128257

2000

m126319

DAS  
28  
9-89

April-16-14 11:00:39 AM

Shop Packet Print

Page 4

# Picklist Print

April-16-14 11:00:39 AM

Page 5

Work Order ID: 116461

**\*116461\***

Parent Item: D407-667-205

**\*D407-667-205\***

Parent Item Name: Aft Crosstube

Start Date: 4/16/14

Required Date: 5/01/14

Start Qty: 1.00

Required Qty: 1.00

AN5-10A

Purchased

No

250

Each

674.0000

10

10

**\*AN5-10A\***

BOLT

**\*\***

DAS  
32  
9-89

Location

Loc Qty

Loc Code

GA

101

122800

101

ST362

366

M127432

66

M128634

300

st503

207

M126180

207

*m128634*

AN5-32A

Purchased

No

250

Each

446.0000

4

4

**\*AN5-32A\***

Bolt

**\*\***

DAS  
32  
9-89

*14/01*

Location

Loc Qty

Loc Code

ST337

114

124215

110

m127363

4

st503

182

m127550

30

m128403

152

ST504

150

m128634

150

*m128403*

April-16-14 11:00:39 AM

Shop Packet Print

Page 5

# Picklist Print

April-16-14 11:00:39 AM

Page 6

Work Order ID: 116461

**\*116461\***

Parent Item: D407-667-205

**\*D407-667-205\***

Parent Item Name: Aft Crosstube

Start Date: 4/16/14

Required Date: 5/01/14

Start Qty: 1.00

Required Qty: 1.00

AN5-34A

Purchased

No

250

Each

206.0000

4

4

**\*AN5-34A\***

Bolt

**\*\***

DAS  
32  
9-89

116  
5  
9

Location

Loc Qty

Loc Code

ST338

106

m126176

6

m127817

14

m127933

36

m128403

50

st503

100

m128634

100

1127933

MS21042L5

Purchased

No

250

Each

1,603.000

4

4

**\*MS21042L5\***

Nut

**\*\***

DAS  
32  
9-89

11/10/11

Location

Loc Qty

Loc Code

GA

5

117611

5

ST315

98

m127304

98

ST509

1500

m127813

500

m128810

1000

1128810

DAS  
28  
9-89

April-16-14 11:00:39 AM

Shop Packet Print

Page 6

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

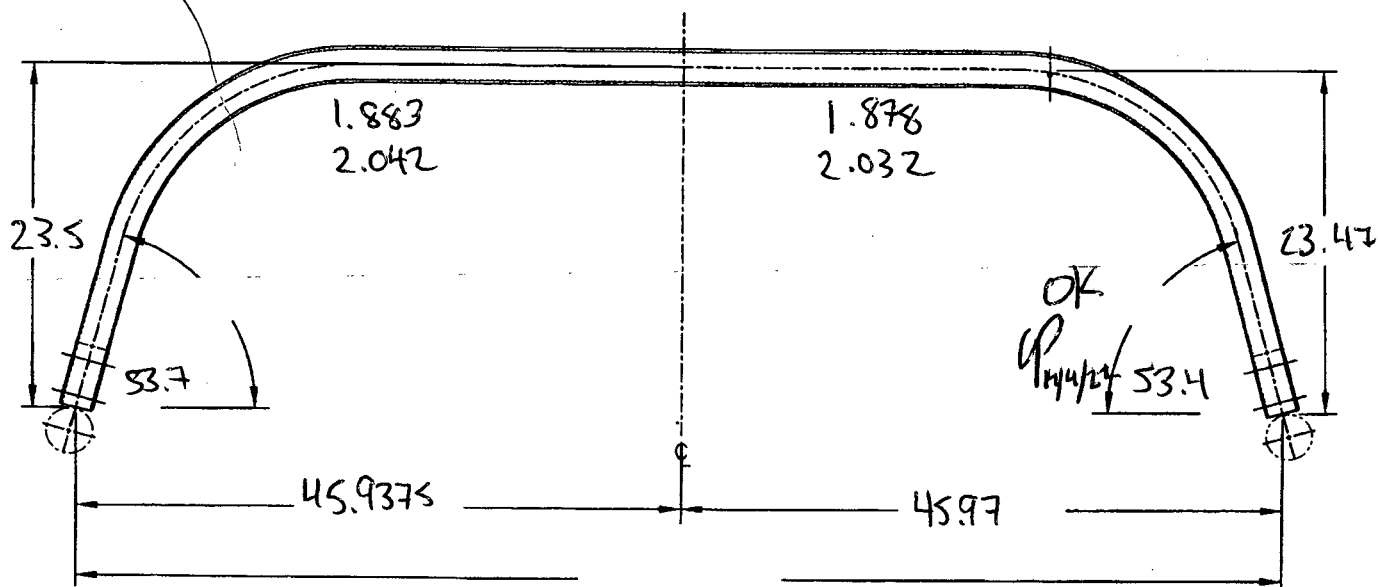
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	116461
<b>Description:</b> Crosstube High Aft (407)		<b>Part Number:</b>	D407-667-205
<b>Inspection Dwg:</b> D407-667-245	<b>Rev:</b> F	<b>Page 1 of 1</b>	

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	45.79	46.05
Angle	54	56
Total Span	91.58	92.100
Bending Passes	6	--
Crushing	--	6%



	Side A	Side B
<b>Bending Passes</b>	30	30
<b>Crushing</b>	4.1%	3.9%
<b>Comments</b>		

<b>QC15 Inspection</b>	<b>Date</b>
	14-4-22

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.06.22	Dwg Rev updated	KJ	
C	11.08.22	Dimensions updated	KJ	
D	11.09.30	Dimensions updated	KJ	
E	12.04.16	Added bending, crushing dimensions	KJ	

Item	QTY -245	PART NUMBER	DESCRIPTION
1	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6011-115  
FINISHED LENGTH = 112.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER 'D407-667-245' AND BATCH NUMBER ON  
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 27.7 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND  
6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO  
PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE  
SUPPORT.  
**NOTE:** MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS.  
ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF  
CROSSTUBE, PER QSI 035.
- 16) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE  
OPPOSITE D2894-1 SUPPORT.
- 17) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

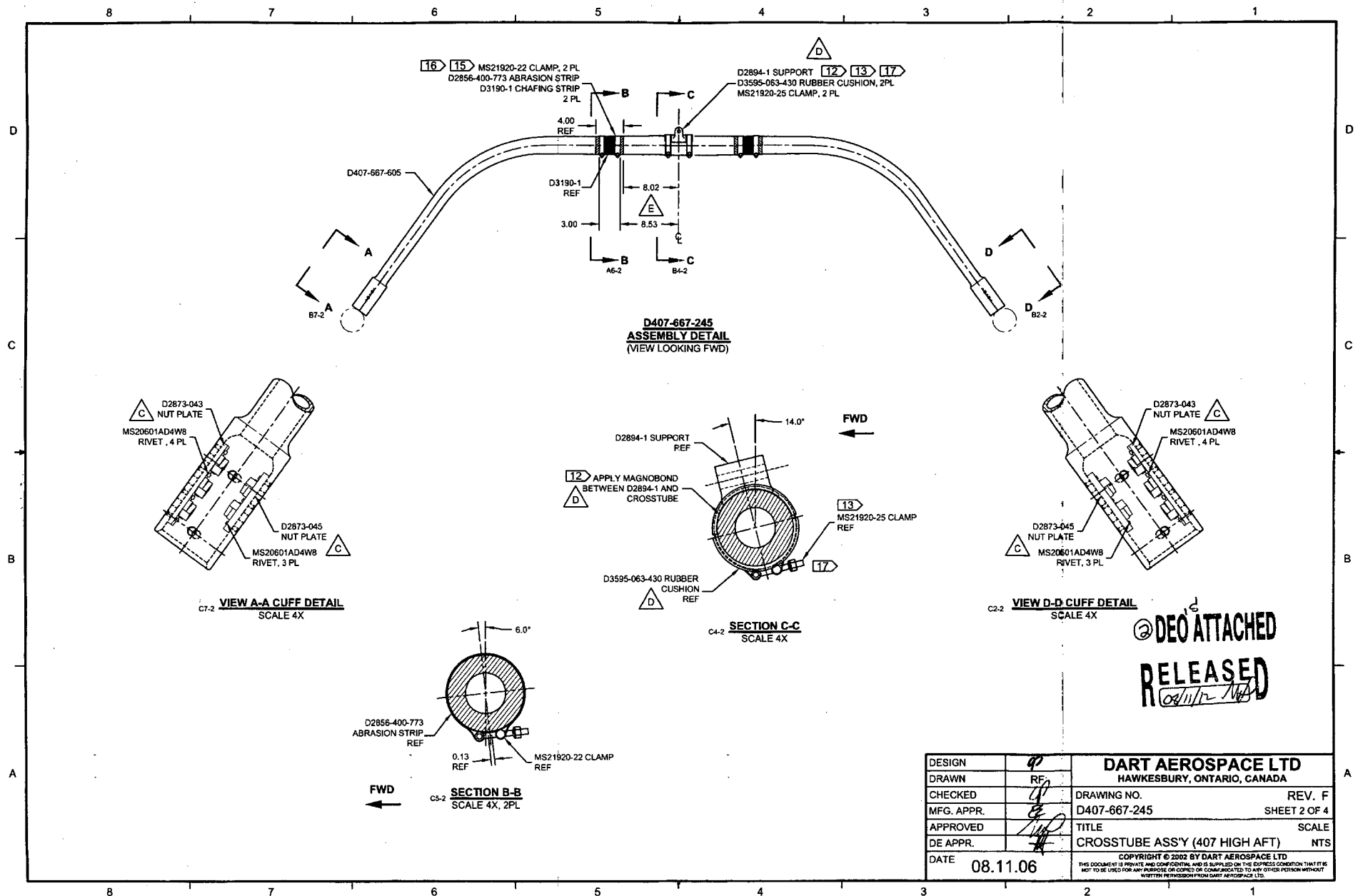
116461 MJS  
14-04-16

② DEO ATTACHED

RELEASED  
8/11/12 MJS

F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: FAR#08-21 AND ECR#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	Q		
DRAWN	RF		
CHECKED	Q		
MFG. APPR.	Q		
APPROVED	Q		
DE APPR.	Q		
DATE	08.11.06		

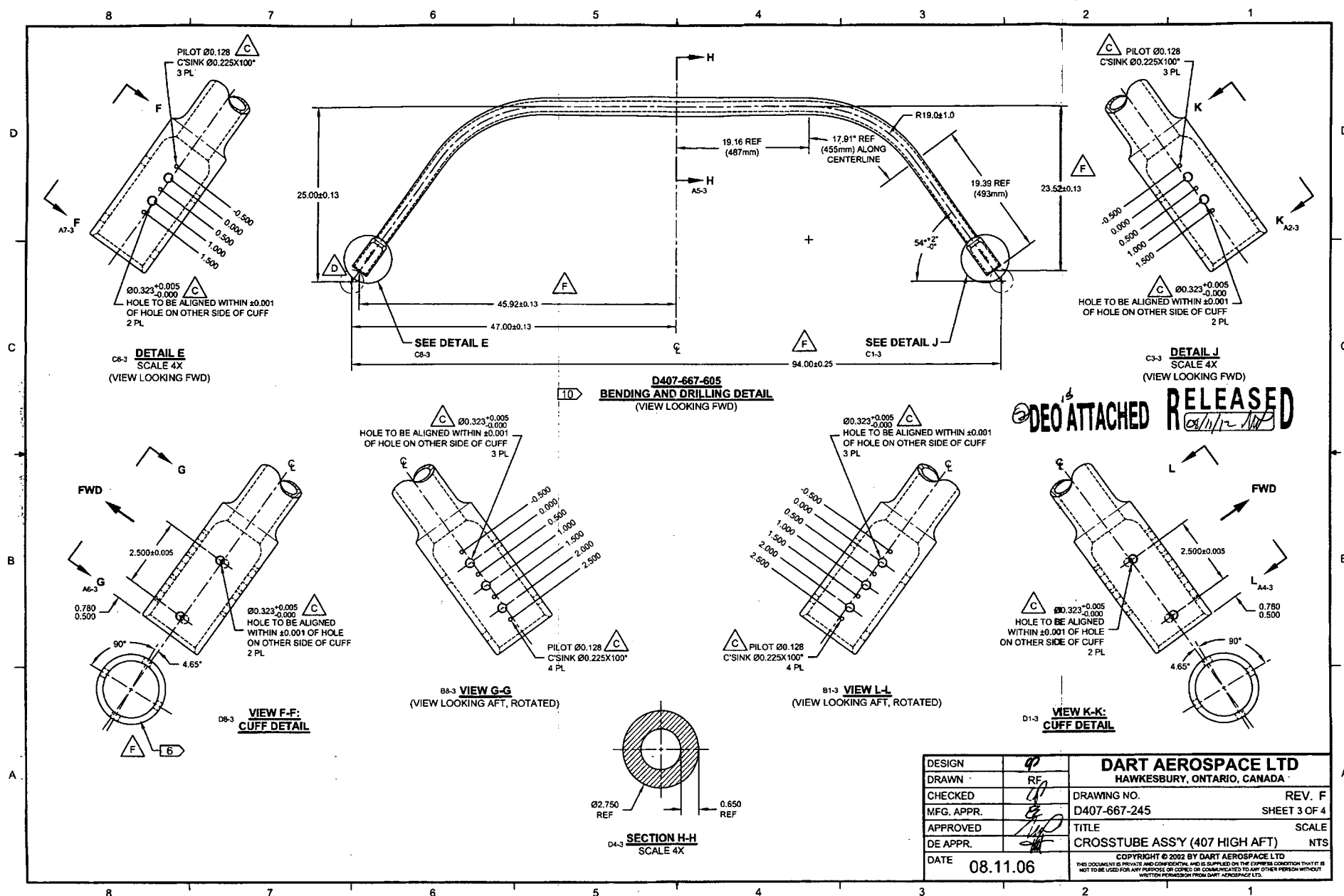
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D407-667-245	REV. F SHEET 1 OF 4
TITLE CROSSTUBE ASSY (407 HIGH AFT)	SCALE NTS
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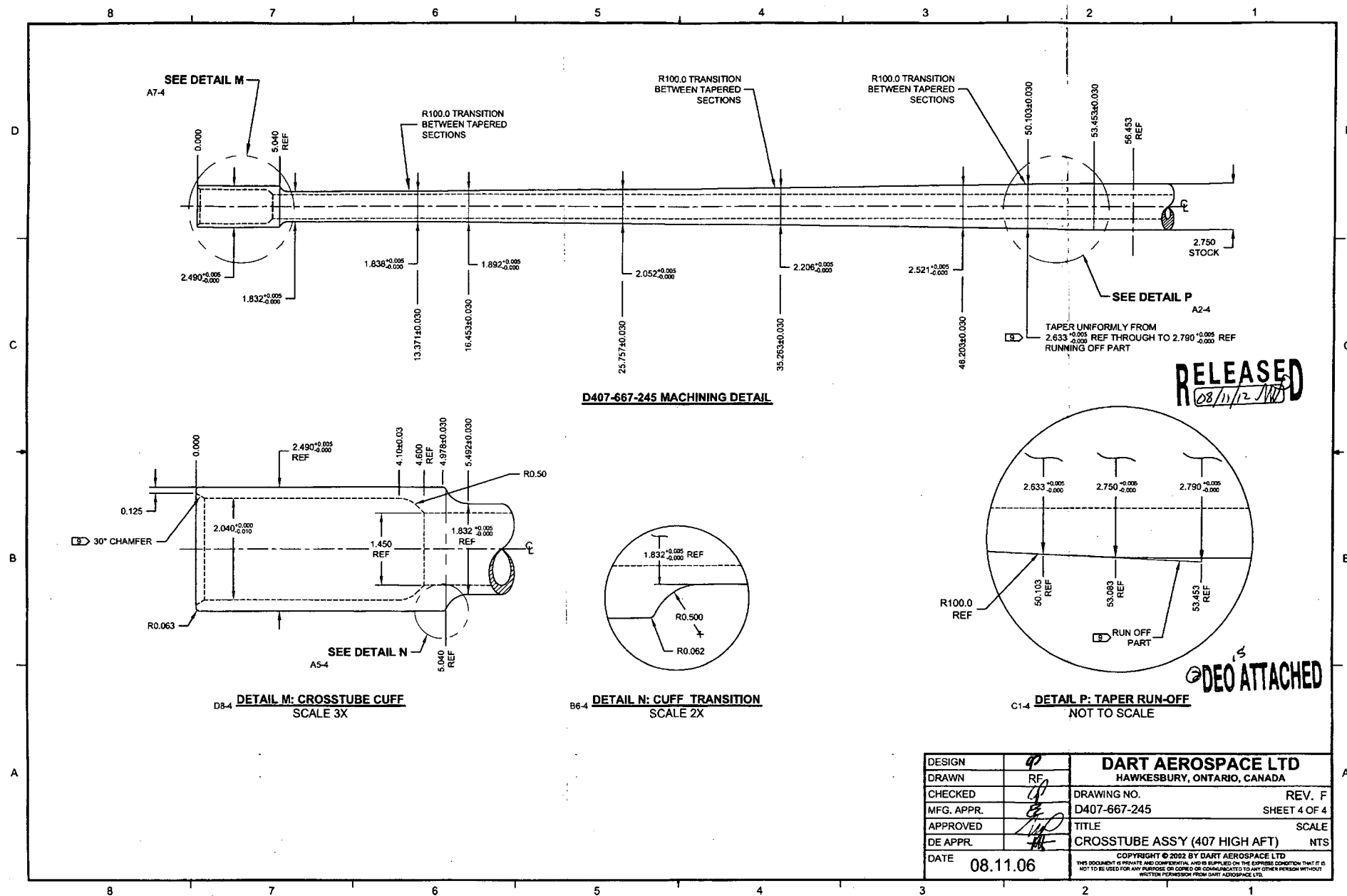


2 DEO ATTACHED  
RELEASED  
08/11/06









DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. F
MFG. APPR.	SE	D407-667-245	SHEET 4 OF 4
APPROVED	TH	TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DRAWING NO. D407-667-245	TITLE CROSSTUBE ASSY (407 HIGH AFT)	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D407-667-245-F-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN 1	CHECKED 40	MFG. APPR. E	APPROVED 160		DE APPR. H		
DATE 11.04.08	DATE 11.04.12	DATE 11.04.12	DATE 11.04.12		DATE 11.04.12		

**PURPOSE:**

REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890.

**CHANGE:**

PARTS LIST IS AMENDED AS FOLLOWS:

**IS:**

Item	Qty -245	Part Number	Description
3	0	D2856-400-773	ABRASION STRIP

**WAS:**

3	2	D2856-400-773	ABRASION STRIP
---	---	---------------	----------------

NOTES 2 AND 15, SHEET 1 ARE AMENDED AS FOLLOWS:

**IS:**

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA) AND  
PAINT OUTSIDE PER DART QSI 005 4.2  
REMOVE MASKING AND APPLY CLEAR COAT
- 15) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3190-1  
CHAFING SHIELDS AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL  
PROSEALED D3190-1 CHAFING SHIELDS ONTO CROSSTUBE BY APPLYING A THIN COAT  
OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

**WAS:**

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 REF GAP ON BOTTOM SIDE OF  
CROSSTUBE PER QSI 035.

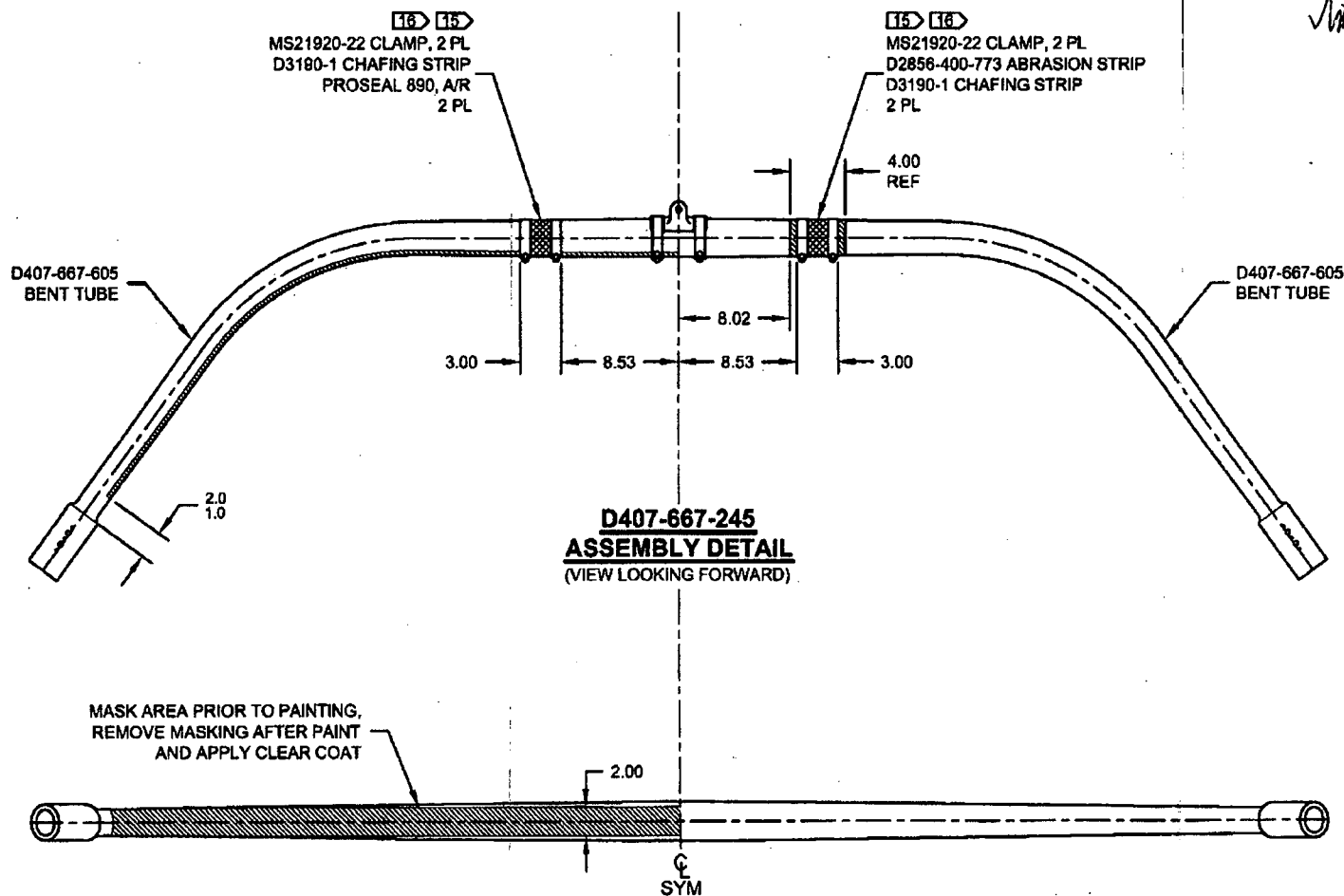
**RELEASED**  
2011-04-18  
M

DRAWING NO. D407-667-245	TITLE CROSSTUBE ASSY (407 HIGH AFT)	REV. F	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D407-667-245-F-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN	CHECKED <i>UP</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>	DE APPR. <i>H</i>		
DATE 11.04.08	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12		

IS:

WAS:

**RELEASE**  
2011-04-18  
*W*



**skyservice****Work Order Traveler**  
Sky Service F.B.O. Inc.

Page: 1 of 1

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO20715	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 23989
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN: 0	CSN: 0	TSO: 0	
Task: <b>UNSCHEDULED</b>			Sequence: 1

**Work Required:****CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 5 CROSSTUBES**

ITEM ID: D407-667-205 AFT CROSSTUBE

1 - WORK ORDER ID#: 116463

2 - WORK ORDER ID#: 116461

3 - WORK ORDER ID#: 112865

4 - WORK ORDER ID#: 112864

5 - WORK ORDER ID#: 116464

DAS  
27  
9/29  
14/4/29

<b>Action Taken:</b>						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-5) AS PER ASTM1417M-13						APR 29 2014	
NO CRACK FOUND							
Pen: ZL-56 BATCH# 09H094 EXP. DATE: AUG 2014, DEV: SKD-S2 EXP. DATE: OCT2017 CLEANER: SKC-S EXP. DATE: APR 2018							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp DOT APP 177 53-89	Date: APR 29 2014
Name: <b>ANTONINO MARCHETTA</b>		



DRAWING NO. D407-667-245	TITLE CROSSTUBE ASS'Y (407 HIGH AFT)	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D407-667-245-F-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 97	CHECKED AS	MFG. APPR. E	APPROVED MP	DE APPR. TH			
DATE 11.09.07	DATE 11.09.19	DATE 11.09.19	DATE 11.09.19	DATE 11.09.19			

**PURPOSE:**

REPLACE MAGNOBOND WITH 3M DP460 SCOTCH-WELD EPOXY ADHESIVE

**CHANGE:**

IS:

Item	Qty -245	Part Number	Description
12	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD

WAS:

12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
----	-----	----------------	---

NOTE 12 & 17, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

WAS:

- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

**RELEASED**  
2011-09-29  
MP

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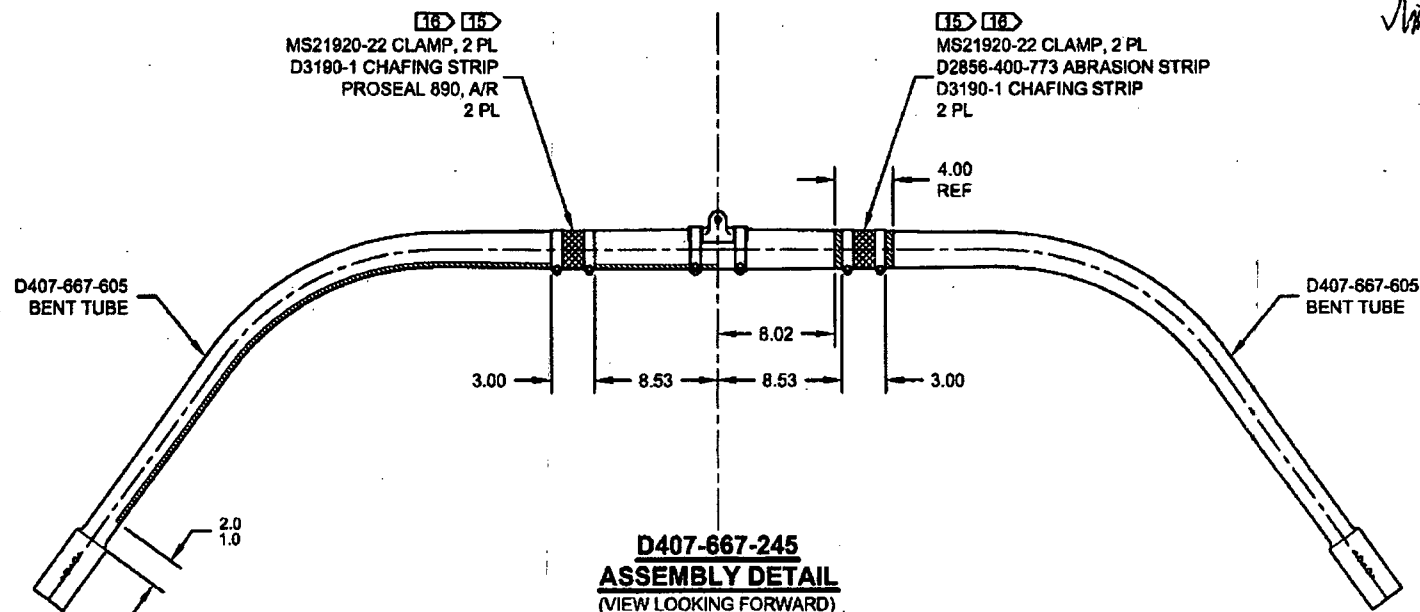


DRAWING NO. D407-667-245	TITLE CROSSTUBE ASSY (407 HIGH AFT)	REV. F	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D407-667-245-F-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN	CHECKED <i>up</i>	MFG. APPR. <i>EE</i>	APPROVED <i>W</i>	DE APPR. <i>H</i>		
DATE 11.04.08	DATE 11.04.11	DATE 11.04.12	DATE 11/04/12	DATE 11.04.12		

IS:

WAS:

**RELEASED**  
2011-04-10  
*W*



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# Work Order ID 116461

**\*116461\***

Page 1

April-16-14 11:00:36 AM

Item ID: D407-667-205

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Crosstube

Start Date: 4/16/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/01/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-04-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D407-667-245	Rev F/DEO								

100 Document Control 0.00  
**\*100\***  
DC DOCUMENT CONTROL  
Memo 0.00  
Doc. Control -USB or Paperwork Photocopy bluefile and create labels as per PPP D407-667-205 CHG008

MLS 14-05-12

110 Pick Kit 0.00  
**\*110\***  
Packaging Packaging Memo 0.00

PL/TW 14-04-21

120 BENDING MACHINE - CROSSTUBES 0.00  
**\*120\***  
CNC Bend 1 Memo 0.00  
CNC Delta 100 Bender 1-Bend tube as per Dwg D407-667-245 using CNC bender program 407 Aft and Folio 21

TH 14-04-21

